

JUN 29 2018

phw



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Hawkesbury, ON
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Tel (613) 632-5200

D350-600-249**Job Sheet 180123****Part No:** D350-600-249**Job Qty:** 2 ea**Part Name:** Spacepod™ Fwd Opening Upgrade Hardware Only**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 6/29/18**Job Tracking No:****Due Date:** 7/17/18**Created By:** Linda Lacelle**Type:** SOLD**Description:**

Note: D350-600 rev.E IPP Rev:A new issue 07.01.31 EC IPP Rev:B 11.02.07 added missing AN960JD8 washer DD
verf:JLM IPP REV:A 11.04.27 added 1 D3554-7 DD verf:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	2 Ea	7/17/18	7/17/18	0.00	0.00	Start Up Stores/Pkg-2			JUL 16 2018
110	Packaging	2 pcs	7/17/18	7/17/18	0.00	0.00	Packaging1-3			JUL 16 2018
120	QC	2 pcs	7/17/18	7/17/18	0.00	0.00	QC4			SRB 28
125	DC	2 pcs	7/17/18	7/17/18	0.00	0.00	DC			SRB 9-88 DAS
130	Packaging	2 pcs	7/17/18	7/17/18	0.00	0.00	Packaging3-1			DAS 28
140	QC21-FG	2 Ea	7/17/18	7/17/18	0.00	0.00	QC21			21 JUL 19 2018 9-88

Part Op 110 - Packaging

Descriptions: 125 - Photocopy bluefile & type labels per PPP 350-600-249 CHG002

130 - Identify and pack for shipping as per PPP D350-600-249 Location: _____ PPP Rev: _____

4427

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
AN526C832R24	Screw	8 Ea (4 ea)	90-Start up Operation	F124255
A3235-020-935	Washer, Countersunk	2 Ea (1 ea)	120-QC	F1134376-25
AN5-5A	Bolt	2 Ea (1 ea)	120-QC	F1133363
AN526C832R10	Screw	20 Ea (10 ea)	120-QC	F11275631 2006312
AN526C832R14	Screw	12 Ea (6 ea)	120-QC	F1133632
D2228	Backing Plate	4 Ea (2 ea)	120-QC	F105980
D2237	Striker Plate	2 Ea (1 ea)	120-QC	5051640
D2464	Neoprene Seal (\$Per Foot)	6 ft (3 ea)	120-QC	F124916
D3015-3	Locknut	4 Ea (2 ea)	120-QC	506871
D3538-1	Hinge Bracket	4 Ea (2 ea)	120-QC	5076840
D3547-1	Bracket	2 Ea (1 ea)	120-QC	F110021
D3550-1	Strut	2 Ea (1 ea)	120-QC	F1160811
D3552-7	Door Prop	2 Ea (1 ea)	120-QC	F116783 F163313
D3554-7	Ball Stud	4 Ea (2 ea)	120-QC	5046605
D3557-1	Bracket	2 Ea (1 ea)	120-QC	F102443
D5127-1	Shim, Large	4 Ea (2 ea)	120-QC	F126308
MS20426AD4-5	Rivet	4 Ea (2 ea)	120-QC	F128839
MS21042L08	Nut	44 Ea (22 ea)	120-QC	5053710
MS21042L5	Nut	2 Ea (1 ea)	120-QC	505878
MS24694-S69	Screw	2 Ea (1 ea)	120-QC	F112492
MS27039-08-11	Screw	4 Ea (2 ea)	120-QC	F1138336-10
MS27039-1-25	Screw	2 Ea (1 ea)	120-QC	F1127432
NAS1149D0332J	Washer	2 Ea (1 ea)	120-QC	5055396
NAS1149D0363J	Washer	2 Ea (1 ea)	120-QC	5015289
NAS1149D0563J	Washer	8 Ea (4 ea)	120-QC	5068662
NAS1149DN832J	Washer	48 Ea (24 ea)	120-QC	5034411
NAS1515H3	Washer	4 Ea (2 ea)	120-QC	F1131697-25
D5127-3	Shim, Small	4 Ea (2 ea)	140-QC21-FG	F128941
MS21042L3	Nut	4 Ea (2 ea)	140-QC21-FG	5078167

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN526C832R24	8	42	0
120-QC	A3235-020-935	2	82	0
	AN5-5A	2	147	0
	AN526C832R10	20	100	0
	AN526C832R14	12	110	0
	D2228	4	14	0
	D2237	2	48	0
	D2464	6	597	0
	D3015-3	4	303	0
	D3538-1	4	9	0
	D3547-1	2	13	0
	D3550-1	2	4	0
	D3552-7	2	9	0
	D3554-7	4	10	0
	D3557-1	2	4	0
	D5127-1	4	13	0
	MS20426AD4-5	4	2,301	0
	MS21042L08	44	1,654	0
	MS21042L5	2	928	0
	MS24694-S69	2	31	0
	MS27039-08-11	4	1,391	0
	MS27039-1-25	2	71	0
	NAS1149D0332J	2	1,549	0
	NAS1149D0363J	2	1,721	0
	NAS1149D0563J	8	1,664	0
	NAS1149DN832J	48	1,674	0
	NAS1515H3	4	196	0
140-QC21-FG	D5127-3	4	13	0
	MS21042L3	4	1,209	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	QTY Effective : _____		MRB (QSI042) Approval		
er Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
FAULT CATEGORY					
Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	
Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____					

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Container No: S092214

Part: D350-600-249

Job No: 180123

Serial No/Batch: S092214

Revision: E
 Inspector:
 Exp Date:
 Instructions:

on

Date: 07/16/18

Part Specifications
Specifications could not be found.

Plex 6/29/18 7:54 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

Change Record

PAGE 1 OF 1

Part Number: D350-600-249

Description: SPACEPOD UPGRADE

[illegible]

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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